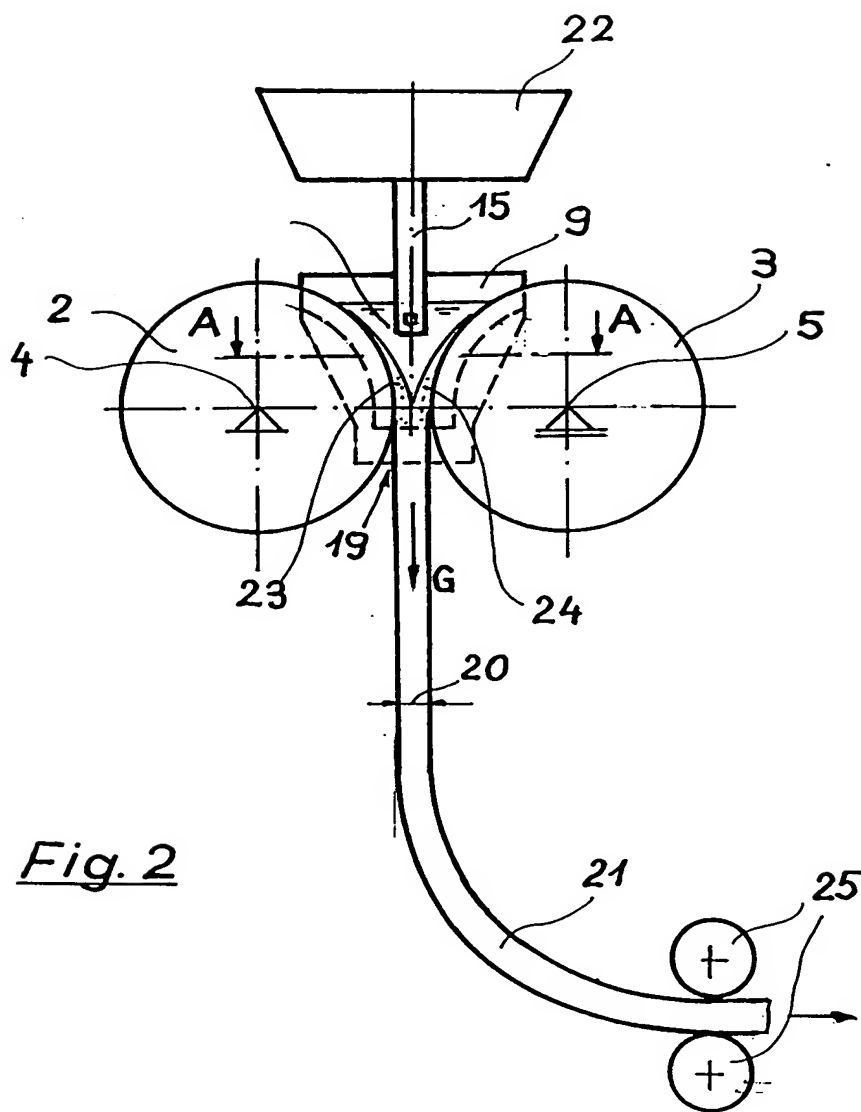
Fig. 1



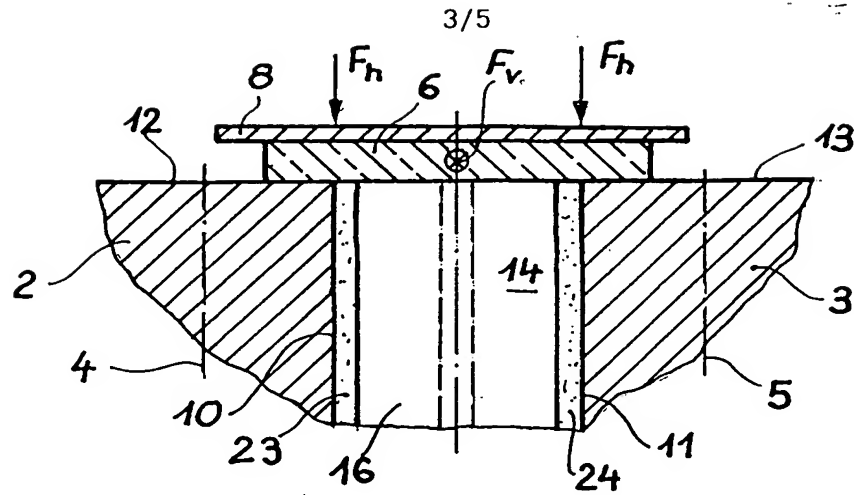


Fig. 3

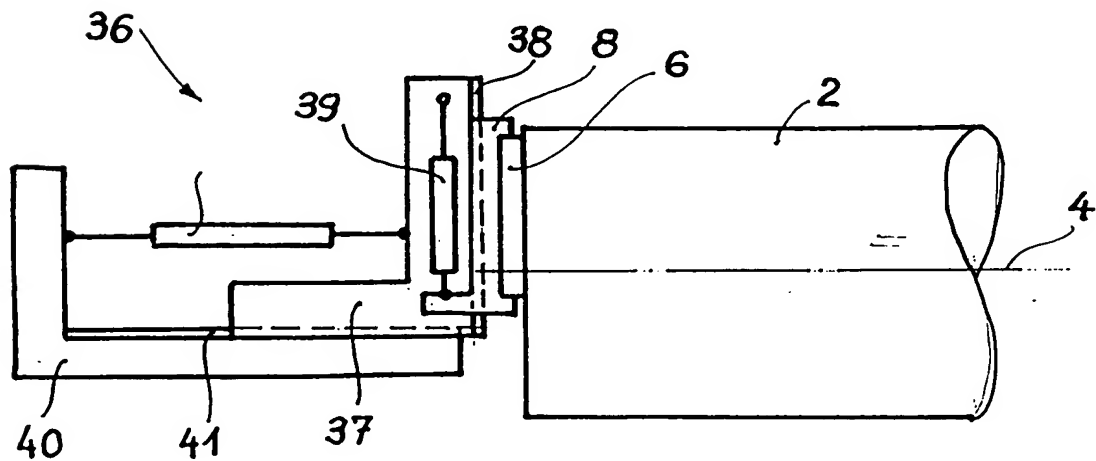
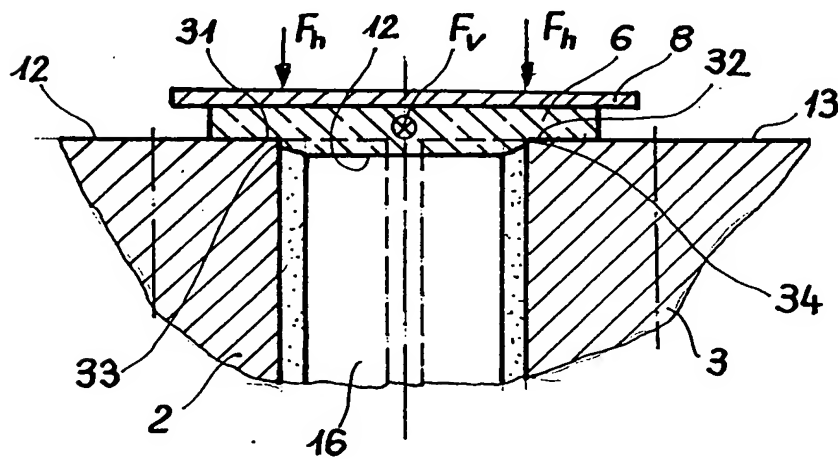
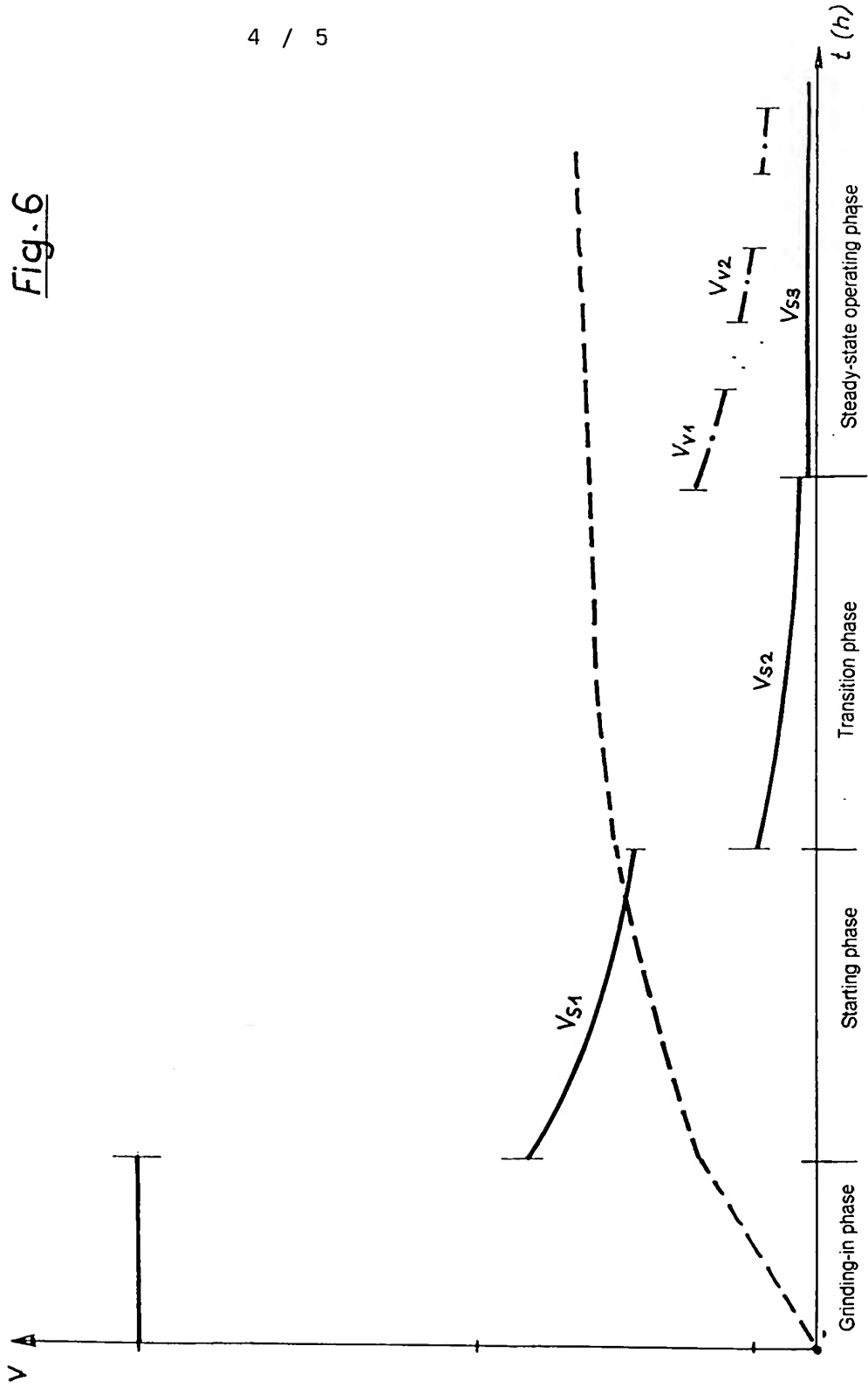
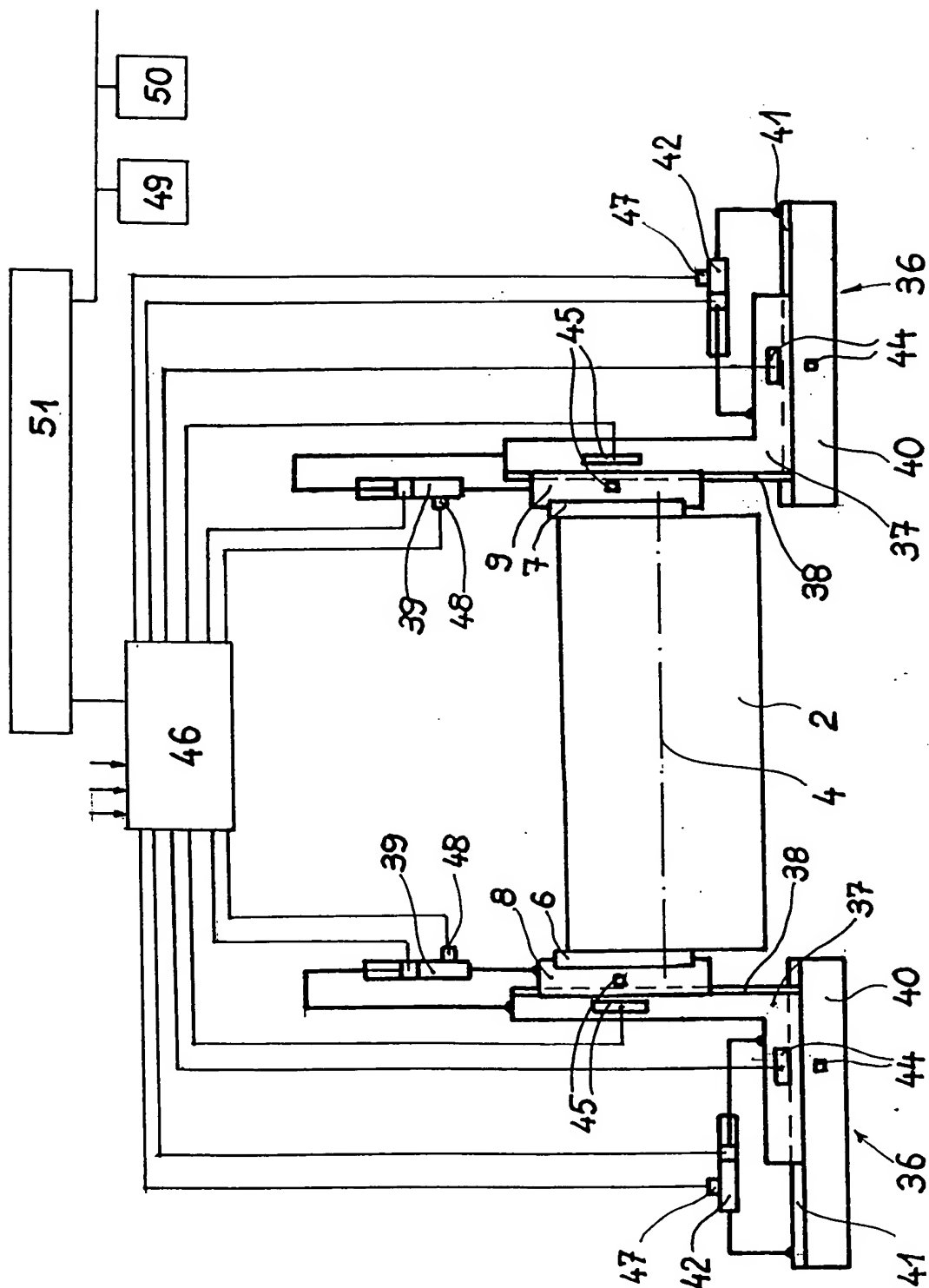


Fig. 6

Horizontal feed rate v_h (mm/h)
 Vertical feed rate v_v (mm/h)
 Horizontal side plate wear (mm)



Fig. 7